

**PRODUCTION OF METAL CASTINGS**

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**Abstract**

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Sound castings (1), free from aluminium pick-up, are produced in moulds (2) in which are located at places where it is desirable to promote directional solidification lining pads (9) made from a composition which comprises particulate refractory material, finely divided aluminium, an oxidising agent for the aluminium and a binder, and which is substantially free of fluoride salts, which contains a fibrous refractory material and which has a density of 0.3 to 1.1 g/cms. The composition may be incorporated as a preformed pad, or as a flexible mat or mouldable mixture which can be dried or hardened chemically.

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(57) Abstract

Sound castings (1), free from aluminium pick-up, are produced in moulds (2) in which are located at places where it is desirable to promote directional solidification lining pads (9) made from a composition which comprises particulate refractory material, finely divided aluminium, an oxidising agent for the aluminium and a binder, and which is substantially free of fluoride salts, which contains a fibrous refractory material and which has a density of 0.3 to 1.1 g/cm<sup>3</sup>. The composition may be incorporated as a preformed pad, or as a flexible mat or mouldable mixture which can be dried or hardened chemically.

